Work Order ID 1028 [June-12-13 9:14:39 AM	16	\ .	*102	2816*							Page 1
Item ID: D3204-3			Accept	*N.900	040	1100)* s	Setup S	tart	*NS	S1*
Item Name: Arm		4					*,r	S	top	*N.	S 2*
Start Date: 6/11/13 S	start Qty: 16.00	*16*		Cust Item I	D: 🔭			4			
Required Date: 6/11/13 FReference:	Req'd Qty: 16.00	*16*		Customer:		K .					
Approvals: Process Plan:	MIJ	Date: 13-06-12	7_Tooling:	Da	ıte:		ŀ		tart	*NI	₹1*
QC:		Date:		Da	ate:			S	top	*NI	₹2*
idiometrial ≣e	peration escription	/	Set Up/ Run Hours	Tool ID	Tool.#	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp
Draw Nbr Revision	on Nbr	-									•
D3204 Rev A	1				• 1.					<u>.</u>	
100 *100* Bandsaw	AND SAW Memo		0.00	N	H	12/06	5/23	- 10	5		·
Jeaspa Bandsaw		00" x 0.50" x 6.520" long	Bar (+0.030/-0.000)			. 7	9/ 22			٠	۵ بندی آدادها با
110	IAAS CNC VERTICAL	MACHINING #1	0.00	" DK/	B 1	3/07	/18	16 q	/		
11 0 : Ha'as i	Memo		0.00							,	
HAAS CNC vertical machine #1		s per Folio FA344 and Dv	vg D32042- Deburrldent	ify as D3204-							
	QC2- Inspect parts off ma	chine FAI/FAIB	0.00	w)	b.a	13/0	3/15	16 /		,997 °	
120	Memo		0.00	1							

Memo

Quality Control

DQA:		Date:						•				*	™ ∆∧DT
QA Closed:		Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE	٠.	ork Order up	ndate only		AEROSPACE
QA Closed.		Date.								,		ш	
Work Order:					DISPOSITION			AGAINS	T DEI	PARTMENT,	/PROCESS		
					Rework	1		Skid-tube Crosstube	еП		Water Jet		Engineering
Part No.					Scrap	1		Machining Small Fal	-	Pro	d. Eng. Coor.	\exists	Quality
					Use-as-is		Thern	noforming Finishin	g		re/Packaging		Other
NCR No.					Suspected Unapproved]		Large Fab Composite	e 🔙		Supplier		
	T			D				A -41		C: 0			
Root	Data	Ston	Otre	vesc	ription of work order update	1	Initial	Action		Sign &	Verification		OC Impropriate
Cause	Date	Step	Qty		or non-conformance		ief Eng	Description		Date	verincation	' 	QC Inspector
Design Doc/Data	-												
Equip/Tooling	1												
Handling/Pre													
Material	1												
Operator													
Offset/Setup												ļ	
Process								,					
Supplier	1												
Training	1												
Transport	1												•
Unapproved													
						FA	ULT CAT	regory					
Landing	Gear				General					_			
	Bending				Bend		Folio/P	Program		Outside Dim	ensions		Pressure/Forced
	Centre No	ot Concer	ntric	L	BOM/Route	L	Grain			Over/Under	tolerance		Set-up
	Cracks	-			Broken/Damage/Defect		Hardwa	ire		Part Incorre	ct		Temperature/Cure
	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	issing		Weld
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved			Wrong Stock Pulled
	Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong		
	Heat Trea	ət			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
	Inspectio	· .	Tube		Drawing		Misread	d					
	Marks/Ch				Drill Holes	L	Off-set						
	Turning S				Finish		Out of (Calibration					
1	Wave/Twist in Tube		- 1	Fit/Function	1	Out of	Soguence	-					

Work Orde June-12-13 9:1		2816		*102	2816*					Page 2
Item ID: Revision ID: Item Name:	D3204-3 Arm			Accept	*N90	0040100)*	Setup St	1 \	IS1* IS2*
Start Date: Required Date Reference:	6/11/13 : 6/11/13	Start Qty: 16.00 Req'd Qty: 16.00	*16* *16*		Cust Ite Custom					
Approvals:		n:	Date:	_		Date:			tart *\ top *\	JR1* JR2*
Sequence ID/ Work Center I 130 *1 2 0* QC Quality Control	ID	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00	Tool	D Tool# Plan Code ノス-7-22	Accept Qty	Reject	Reject Numbe	Insp. r Stamp
140 *140* Packaging Packaging		Identify as per dwg & Sto	ock Location:	0.00 0.00			lex			B-7-2
150 *150* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00			·	13	17/2	45

NB-07-23

DQA: Date:						MODIL ODDED NON	~		DRAABICE / LU	DDATE			DART				
QA Closed:			Date:			WORK ORDER NON-	٠. ر ر	JINFUI	RIVIAINCE / UI	Work Order update only							
Work Orde	\r.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS					
WOIK OIUE	:1.	-				Rework			Skid-tube	Crosstube	7	Water Jet	Engineering				
Part N	J۵					Scrap		Machining Small Fab			Pro	d. Eng. Coor.	Quality				
T ditti	••••					Use-as-is			moforming Finishing		Rec/Store/Packaging		Other				
NCR N	NCR No.					Suspected Unapproved				Composite]	Supplier					
Root	-		I	· -	Desc	ription of work order update	-	nitial	Act	tion	Sign &						
Cause		Date	Step	Qty	Desci	or non-conformance		ief Eng	1	ription	Date	Verification	QC Inspector				
Design		Date	Step	αι,		or non comormance	<u> </u>	ici, Ling	36361	трегот	1 2 2 2		Quantity (
Doc/Data		i															
Equip/Tooling									,								
Handling/Pre																	
Material																	
Operator						, ,			•	•							
Offset/Setup																	
Process																	
Supplier						•											
Training																	
Transport					:	•											
Unapproved																	
						•	FAI	ULT CA	TEGORY								
Landi	ng (Gear				General				_	_						
	L	Bending				Bend		Folio/F	Program	_	Outside Dim	ensions	Pressure/Forced				
		Centre No	ot Concei	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up				
;		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ct _	Temperature/Cure				
		Crimp/Kir	nk/Ripple	/Wave		Burrs	L	Inspect	ion Incomplete/Ui	nqualified	Part Lost/M	issing	Weld				
		Cuffs				Contamination		Instruct	tions Incomplete/l	Unclear	Part Moved		Wrong Stock Pulled				
	L	Crushing			L	Countersink		Misali	gned/off center		Positioned V	_	-				
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other				
		Inspectio	n Strip in	Tube		Drawing		Misrea	d								
		Marks/Cl	natter	•		Drill Holes	$oxed{oxed}$	Off-set									
	_	Turning S				Finish		Out of	Calibration								
	Wave/Twist in Tube				Fit/Function	1	Out of	Sequence									

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

June-12-13 9:14:39 AM

Page 1

Work Order ID:

102816

Parent Item:

D3204-3

Parent Item Name:

Arm

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 16.00

Required Qty: 16.00

IPP: C05 08 11Added Step 25 KJ/JLM

Comments:	IFF. C03.08.11A	ducu siep 23 K	.J/J1_1V1	<u>-</u>	منظر <i>-</i>								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.000 6061-T6 Bar .500 x 2.00	:	Purchased	No			100	f	20.8350	0.5538	9.3271584		,	n. um man
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT001		20.835							
				12070)8	2.83				-			
	•			- 12457	73	18.005			9 .3	2 <u>7,1</u> N	H	3/06/	ν3

DQA: Date:						WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:			WORK ORDER NON-	٠	JINFOI	AIVIAINCE / U		Wo	rk Order up	odate only	\Box	AEROSPACE	
Mork Orde						DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Work Orde	er: -					Rework		Skid-tube Crosstube Water Jet						Engineering		
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	\dashv	Quality	
	•					Use-as-is		Thermoforming Finishin					re/Packaging	\exists	Other	
NCR N	10.					Suspected Unapproved			Large Fab	Composite		·	Supplier			
Dont					Doca				Λ α	tion	-	Cian 0	i	$\overline{}$		
Root Cause	-	Date	Step	Qty	Desci	ription of work order update or non-conformance	!	nitial iief Eng		ription		Sign & Date	Verification		QC Inspector	
Design	ᅱ	Date	step	Qty		or non-comormance	Cil	ilei ciig	Desci	прион	\dashv	Date	vermeation	+	QC Hispector	
Doc/Data																
Equip/Tooling	\dashv	٠									1	:		Į		
Handling/Pre	\neg															
Material																
Operator														l	;	
Offset/Setup																
Process												i				
Supplier																
Training																
Transport																
Unapproved																
							FA	ULT CA	regory							
Landi	ng G	ear				General		_		_			_			
		Bending				Bend		Folio/F	rogram			Outside Dim	ensions		Pressure/Forced	
		Centre No	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	ct [Temperature/Cure	
		Crimp/Kir	ık/Ripple	/Wave		Burrs	L	Inspect	ion Incomplete/U	nqualified		Part Lost/Mi	ssing	'	Weld	
		Cuffs				Contamination		4	tions Incomplete/	Unclear		Part Moved			Wrong Stock Pulled	
	-	Crushing			<u> </u>	Countersink		1	ned/off center		-	Positioned V				
	\vdash	Heat Trea				Cut Too Short		Mislabe				Power Loss/	Surge		Other	
		Inspection	٠.	Tube		Drawing		Misrea								
	L	Marks/Ch			<u> </u>	Drill Holes	L	Off-set								
	L	Turning S			<u> </u>	Finish		-1	Calibration				· ···			
	Wave/Twist in Tube			Fit/Function	L	Out of	Sequence									

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	102816
Description: Arm	Part Number:	D3204-3
Inspection Dwg: D3204 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
6.00	+/-0.030	5.996			DR 15	6'vex	
5.25	+/-0.030	5.246			DR 05	6'veren	J.
0.776	+/-0.010	.775			DR 05	6" ven	~ .
Ø0.760	+0.005/-0.000	.758			DR 05	6"ven	w .
0.080	+/-0.010	, 20			DK05	6"VER	n)
R0.50	+/-0.010	.5				GALLE	<u>-</u>
2.373	+/-0.010	2.372			BPUS	6'VERA	Y
0.750	+/-0.010	,752				6'VERN	
R0.380	+/-0.010	.380			RADIN	SGMUGE	
Ø0.375	+0.001/-0.000	. 375			Din	GAUGE	
0.300	+/-0.010	,297	, and the second		Deos	6"vER	
							201
						· ·	
Measured by:	V/h-	Audited by:	5		Prototype A	hnroval:	N/A
Date: //	× / ~ += -		17-2	- 20	. rototype x	Date:	N/A

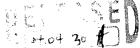
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 13/07/18	Date: 13-2-30	Date:	N/A
Rev Date Change		Revised by	Approved

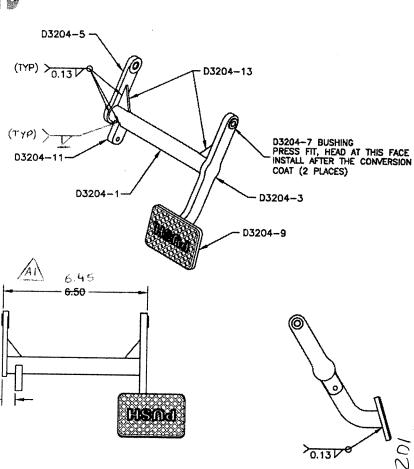
Rev	Date	Change	Revised by	Approved
Α	05.02.17	New Issue	KJ/JLM , ,	- 1
В	06.03.21	Dwg Rev update	KJ/JLM A	





\	DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANA	
	CHECKED,	APPROVED	DRAWING NO.	REV. A
•	#	-H	D3204	SHEET 1 OF 3
	DATE		ПЕ	SCALE
	04.01.27		RELEASE PEDAL ASSEMBLY	NTS
	Α	04.01.27	NEW ISSUE	
	AI CHT	+ 05.07.15	6.45 WAS 6.50	





D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

0.600

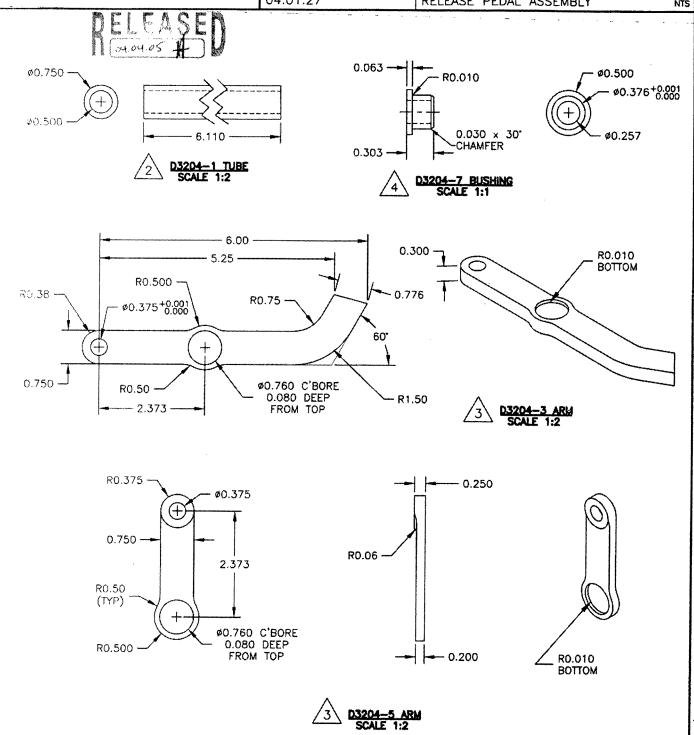
- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/B OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
 ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
 7) WELD ASSEMBLY PER QSI 004

- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 11) ALL DIMENSIONS ARE INCHES





		The same of the sa	
DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECKED	APPROVED	DRAWING NO.	REV. A
411	1	D3204	SHEET 2 OF 3
DATE		TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS



Copyright © 2004 by DART AEROSPACE LTD

LOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

THE RESERVE TO STATE



